

Work Order ID 55813

Tuesday, February 02, 2010 1:10:49 PM



Page 1

Item ID: D3463-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Weldment Assembly

Start Date: 2/3/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 2/12/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: mf

Date: 10-2-2

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3463	Rev B

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld assembly as per dwg D3463 using DT8875								

6x Cpl 10/02/10

Buff material - m-10/02/10 6x

110		0.00							
	QC9- Inspect visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									

PD 10.02.10 6

120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

⇒ 8/10/2011

x6
4x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries




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Revision ID:					Stop	
Item Name:	Step Weldment Assembly					
Start Date:	2/3/2010	Start Qty:	6.00	Cust Item ID:		
Required Date:	2/12/2010	Req'd Qty:	6.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel M113170 Memo 1- Mask areas indicated on dwg D3463 (holes, threads) START TIME: 1:15pm OVEN TEMPERATURE: 400°F FINISH TIME: 1:45pm	0.00 0.00	⇒ JH	10/04/16		(X6)	✓		
140  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch M113462 Memo	0.00 0.00	⇒ M-k	10/02/16		(6X)			
150  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	BR	10-02-17		(B)			

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 494

0.00



Packaging

Memo

0.00

Packaging

10-2-17

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/18

MF

10-2-17

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Picklist Print

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Page 1

Work Order ID: 55813

Parent Item: D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 2/3/2010

Required Date: 2/12/2010

Comments: IPP REV. A 05.11.18 new issue EC IPP revB: replace pressure
with wing walk DD 10.01.28 verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

238-806

Purchased

No

100

Each

60.0000

12.0000



SS DOWEL PIN 1" LONG

Pl 10/02/09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

60

105037

3

111088

53

19080

4

D3453-3

Manufactured

No

100

Each

8.0000

6.0000



Clevis

✓ 12 epc

Pl 10/02/09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

8

52983

8

D3453-5

Manufactured

No

100

Each

27.0000

6.0000



Plug

*stk
✓ (6)*

Pl 10/02/09

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

27

46265

17

52985

10

*stk
✓ (6) epc*

Dart Aerospace Ltd

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with wing walk DD 10.01.28 verified by:EC

Start Date: 2/3/2010

Required Date: 2/12/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3463-1		Manufactured	No			100	Each	0.0000	6.0000			
Arm												
D3463-3		Manufactured	No			100	Each	58.0000	6.0000			
Step												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 58
46149 11
46269 47

D3463-5		Manufactured	No			100	Each	1.0000	12.0000			
End Cap												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1
46270 1

55815 → 11

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Start Date: 2/3/2010

Required Date: 2/12/2010

Comments: IPP REV. A 05.11.18 new issue EC IPP revB: replace pressure
with wing walk DD 10.01.28 verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3463-7		Manufactured	No			100	Each	2.0000	6.0000			
Drag Arm												

Cpd 10/02/09

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

54593

2

** B55814 → (2) pc
(4) pc*

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

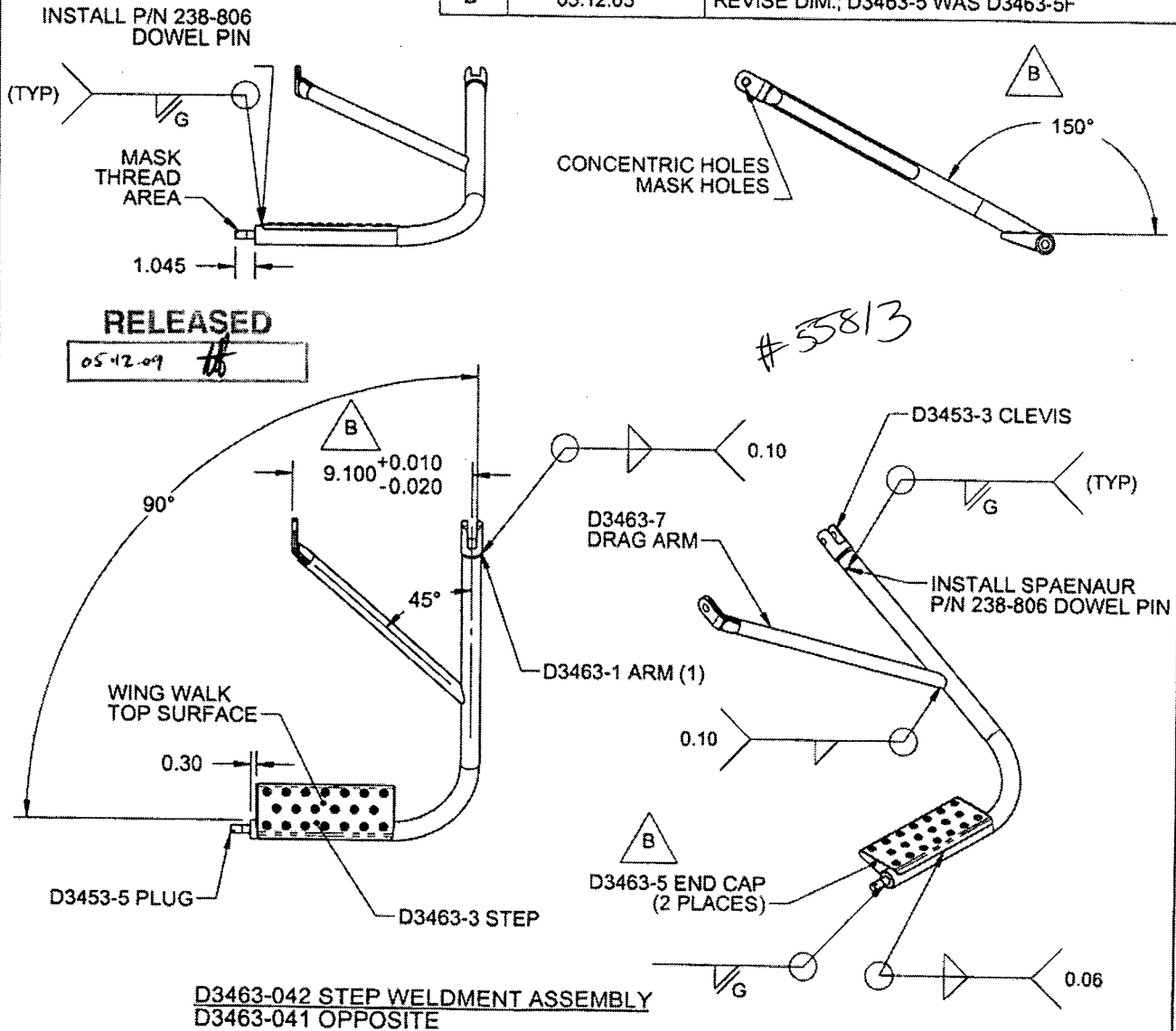
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NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 1 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	

**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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Dart Aerospace Ltd

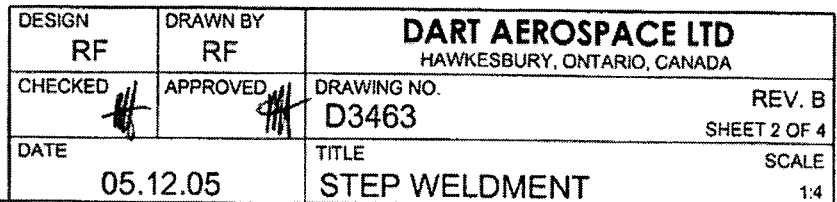
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

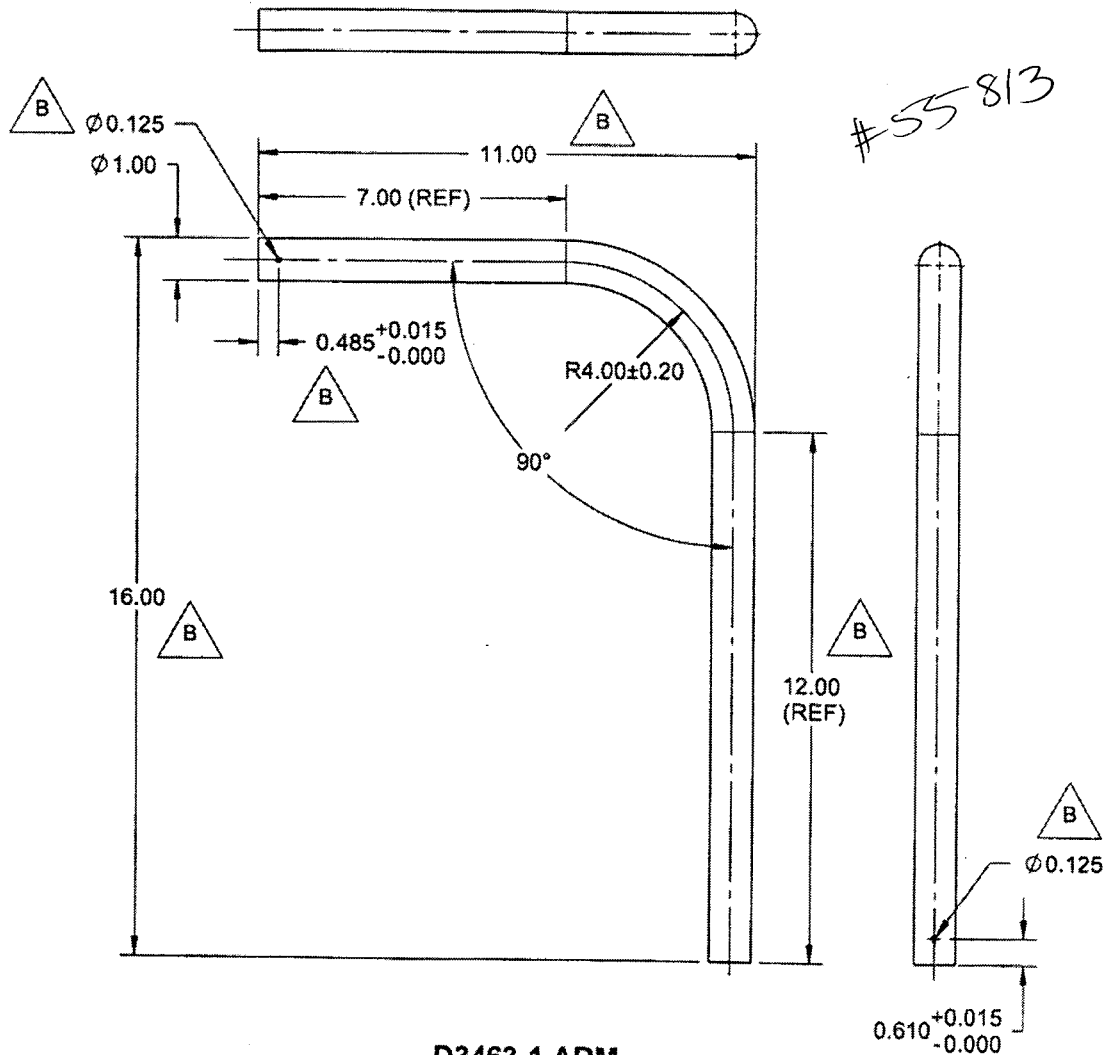
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



05.12.09



D3463-1 ARM

1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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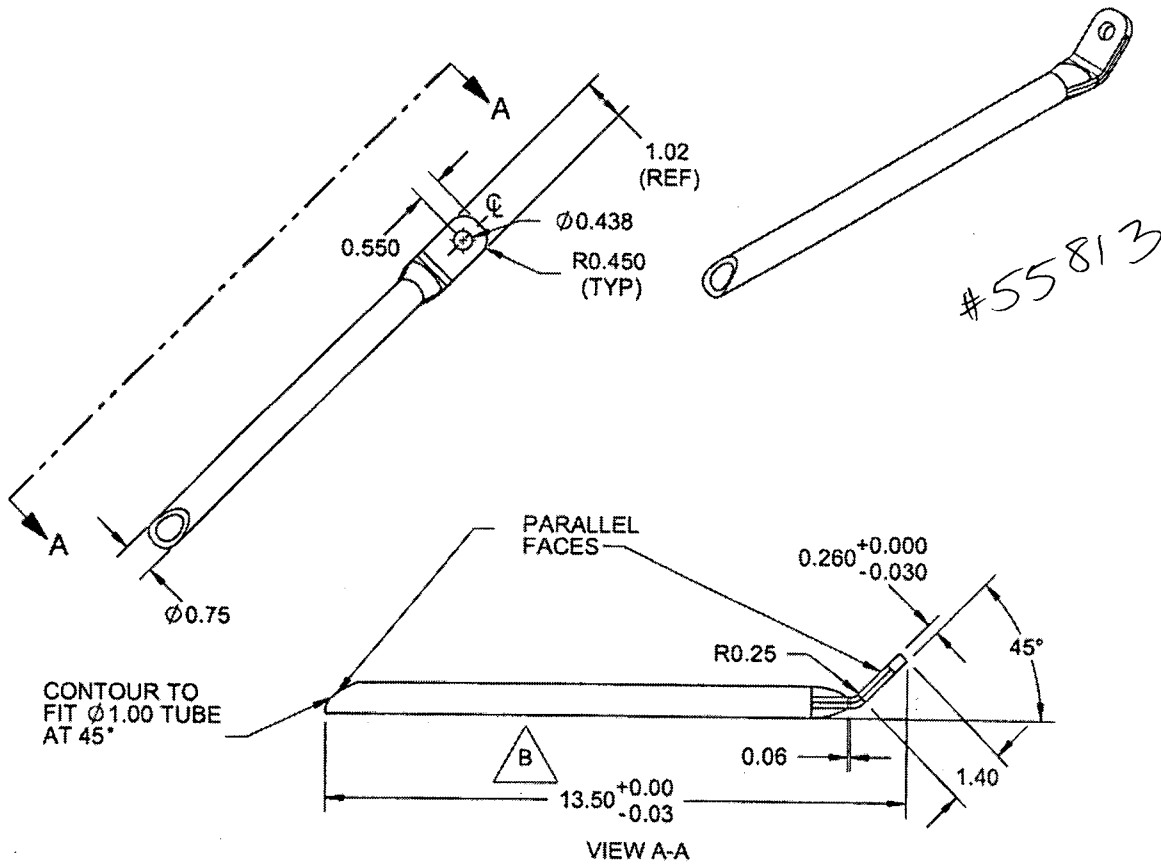
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.09 #

**D3463-7 DRAG ARM****NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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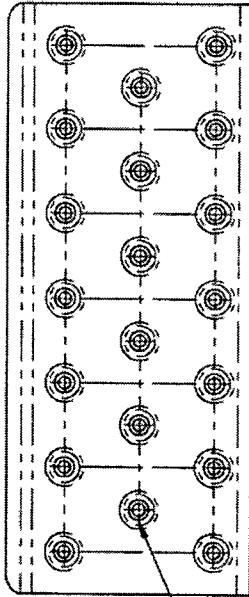
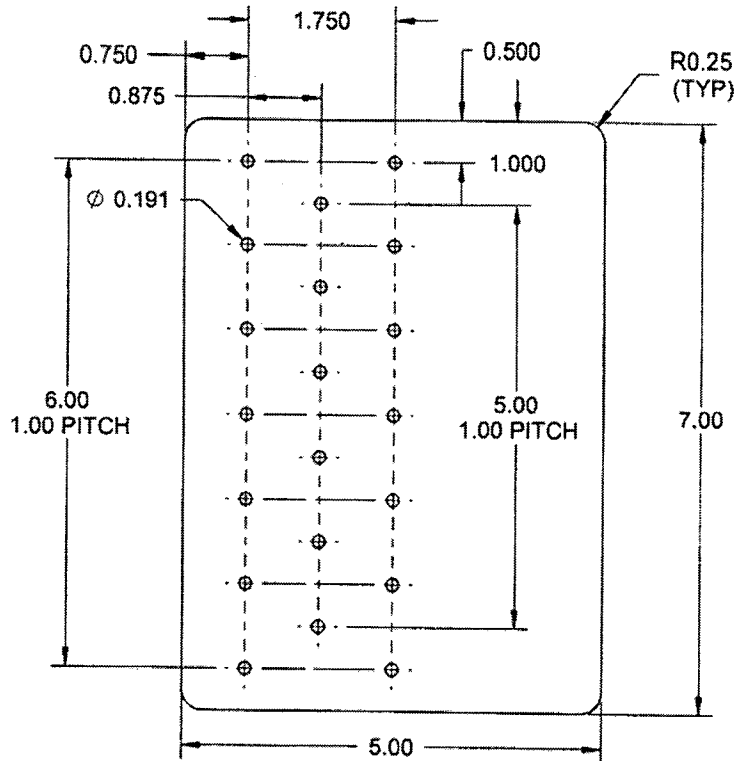
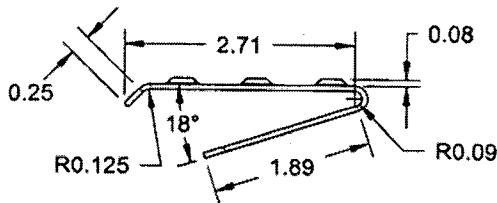
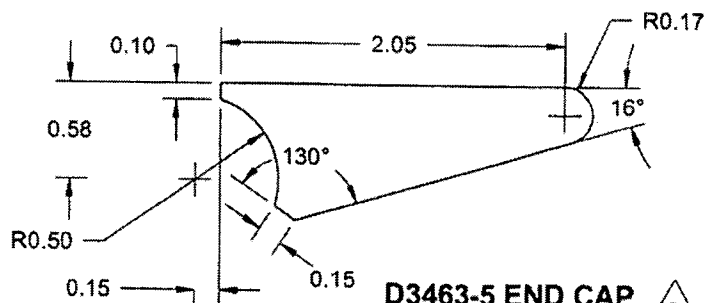
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05	TITLE STEP WELDMENT		SCALE 1:2

RELEASED

05.12.09 #

FORM USING
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

55813

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